

SLUR

Date: Tuesday, 23/09/2008 10:22:38 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 42235		Part Number	: D35371		
Estimate Number	: 12712		Drawing Number	: D3537 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 23/09/2008	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 05/10/2008 Qty: 50 Um: Each		
Previous Run	: 41082					
Written By	:					
Checked & Approved By	: JUL 08.9.23					
Comment	: Est Rev:A New Issue 07-02-14 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0 sf(s)/Unit Total : 6 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 109051 FB 8-10-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

FB 8-10-6

(60) 142

2-Deburr if necessary

FB 8-10-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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FB 8-10-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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5/8/10/66 X60 counter

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

5/8/10/67

(60)



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Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat M109303, M109213

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

EL 8-11-3



7.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Job 08-11-03 (18)



Comment: VISUAL INSPECTION OF GROUND WELDS

8.0 QC5

INSPECT WORK TO CURRENT STEP



Job 08-11-03 (18)



Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING

POWDER COATING



M106442



(18X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

8-30 OF

OVEN TEMPERATURE:

320

FINISH TIME:

9-00

m-1 08/11/04

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HS



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

08-11-04 (X18)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

HS

08-11-04 (X15)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/05 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-04



DART AEROSPACE LTD	Work Order:	42235
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

First Article       Prototype

Measured by:	WB
Date:	24-0-6

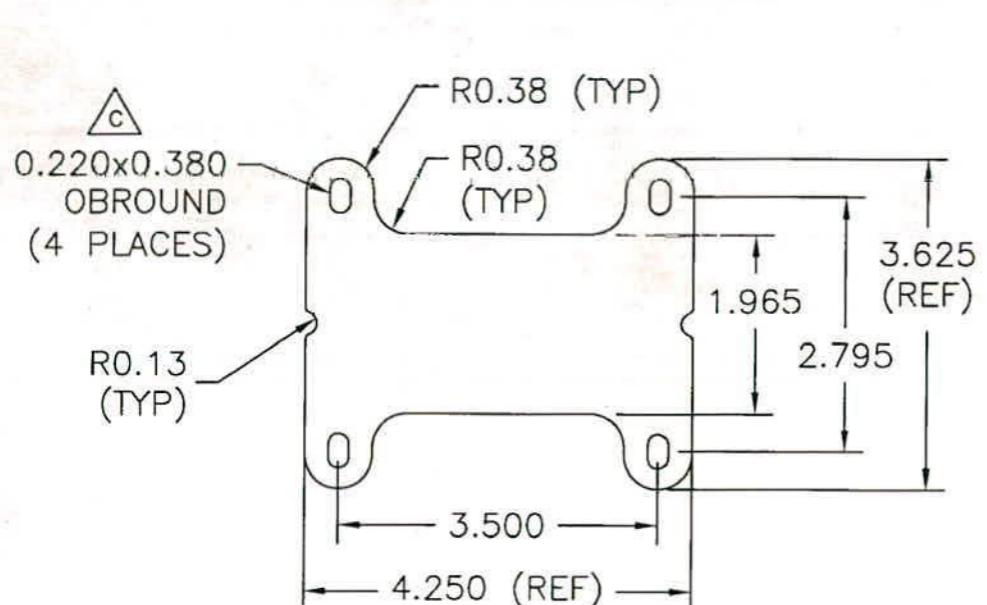
Audited by: [Signature]  
Date: 20/10/06

Prototype Approval:	N/A
Date:	N/A

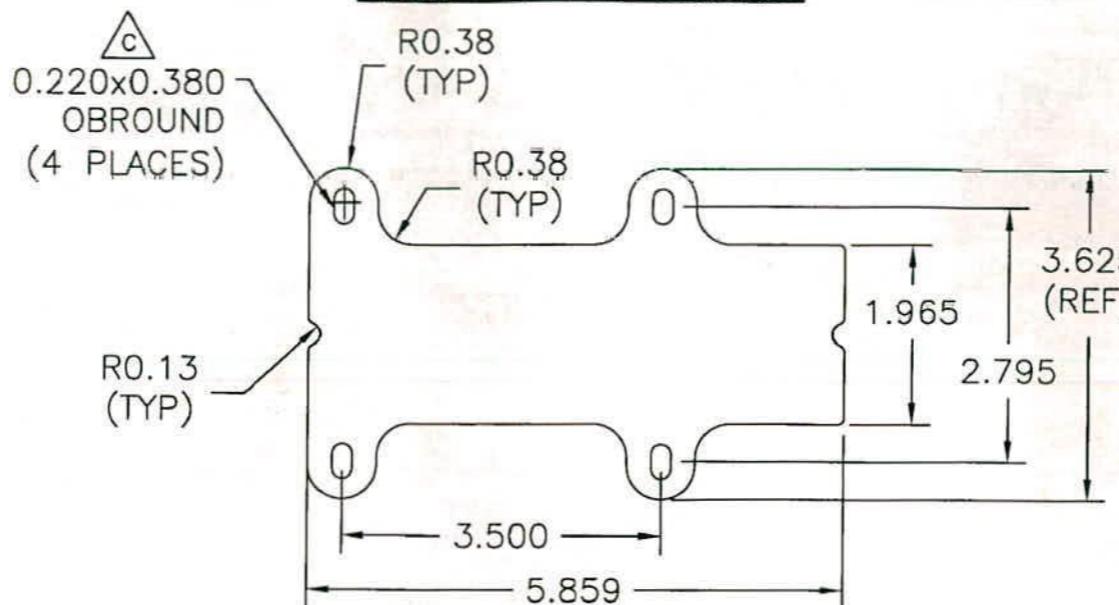
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>



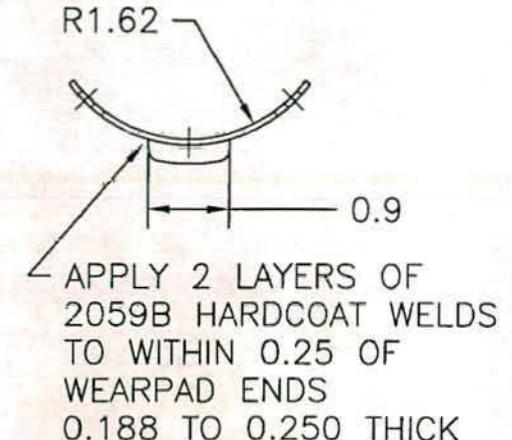
### D3537-1F FLAT PATTERN



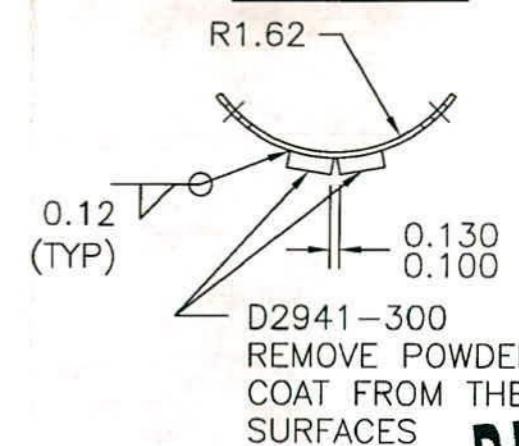
### D3537-3F FLAT PATTERN



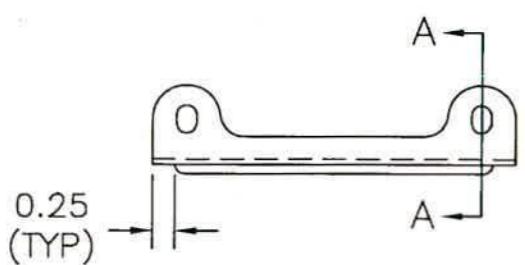
### SECTION A-A



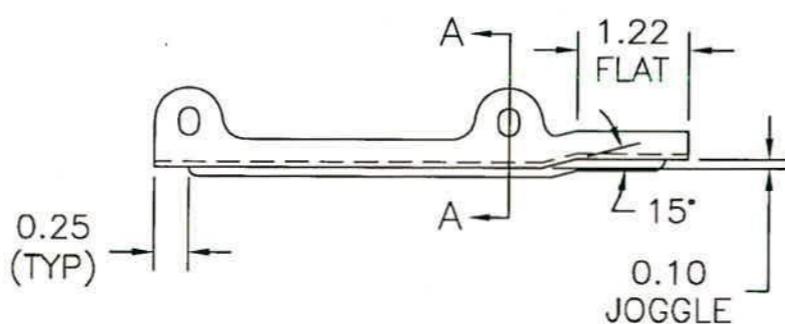
### SECTION B-B



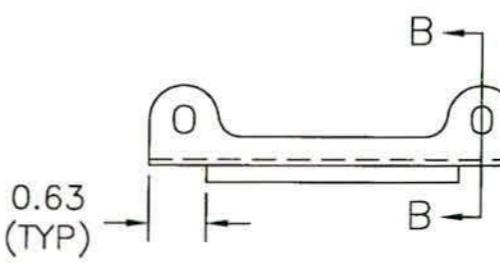
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



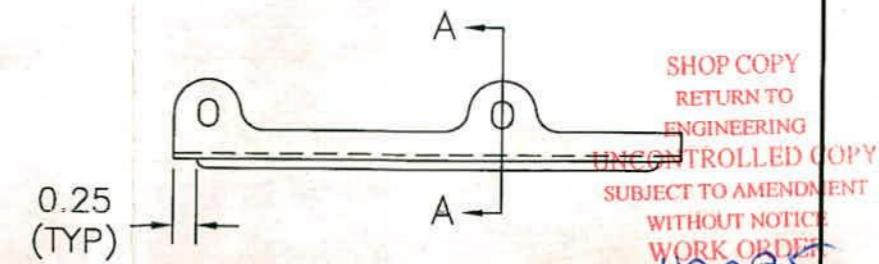
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
C.B	P.H	
CHECKED	APPROVED	DRAWING NO. D3537
		REV. C SHEET 1 OF 1
DATE	TITLE	SCALE
07.04.13	WEARPAD	1:2

